

Work Order ID 86925

86925

Page 1

July-09-12 2:48:59 PM

Item ID: D3238-31 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Plate
 Start Date: 7/09/12 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 7/27/12 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/07/10 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3238	Rev C								

100 0.00
100 FLOW WATER JET 5 0 Jm 12-7-22
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3238 Dwg Rev: C Prog Rev: C 2-
 Deburr if necessary ***Use cutting file D3238-21-23-25*****
6061, 020

110 0.00
110 QC2- Inspect parts off machine FAI/FAIB 5 0 Jm 12-7-22
 QC Memo 0.00
 Quality Control

120 0.00
120 QC8- Inspect parts - second check 5 _____
 QC Memo 0.00
 Quality Control

SMB
12-7-23
DAS
16
9-89
12/8/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86925

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Page 2

July-09-12 2:48:59 PM

Item ID: D3238-31

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Plate

Start Date: 7/09/12

Start Qty: 5.00

5

Cust Item ID:

Required Date: 7/27/12

Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

5 0 06/27-23

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

5 0 06/27-23

150

Identify as per dwg & Stock Location:

8537

0.00

150

Packaging

Memo

0.00

Packaging

06/27-23

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 86925***86925***

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July-09-12 2:48:59 PM

Item ID: D3238-31

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Plate

Start Date: 7/09/12

Start Qty: 5.00

5

Cust Item ID:

Required Date: 7/27/12

Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/7/24 JF
MK
12-07-24

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NOTE: Date & initial all entries

Picklist Print

July-09-12 2:48:58 PM

Page 1

Work Order ID: 86925

Parent Item: D3238-31

Parent Item Name: Plate

Start Date: 7/09/12

Required Date: 7/27/12

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A New Issue 07-01-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.020
6061-T6 Sheet.020

Purchased

No

100

sf

62.7360

0.024

~~0.1263158~~

0.25

Jun 27-22

Location

Loc Qty

Loc Code

MAT021

62.736

112442

14.736

119743

48

119743

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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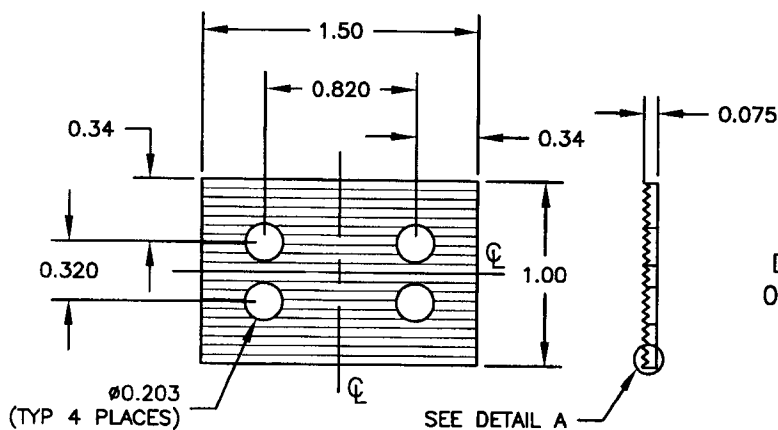
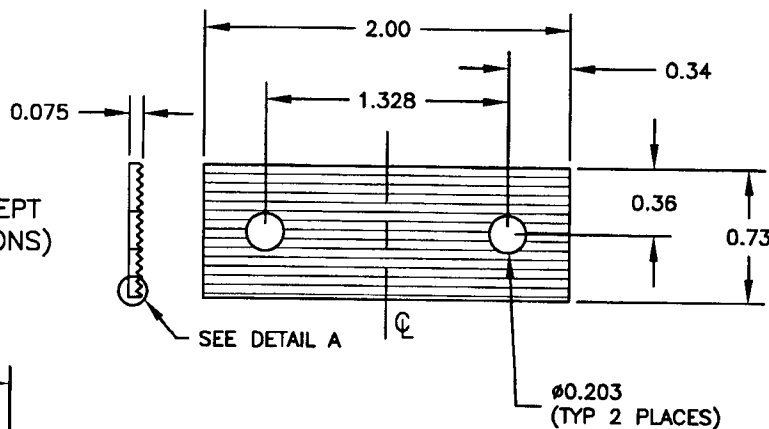
NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 1 OF 3
DATE 07.02.19	TITLE PLATE		SCALE 1:1
A	03.11.25	NEW ISSUE	
B	07.01.17	ADD -21/-23/-25/-31/-33/-35; CHANGE -11/-13/-15 TO 6061-T6	
C	07.02.19	ADD 5052-H32 OPTION	

RELEASED

07.02.20

D3238-1 PLATE (SHOWN)D3238-11 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)**D3238-3 PLATE (SHOWN)**D3238-13 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)**NOTES:**

- 1) MATERIAL -1/-3/-5/-21/-23/-25 PLATE:
ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS 4037
(REF DART SPEC M2024T3S)
-11/-13/-15/-31/-33/-35 PLATE:
ALUMINUM 6061-T6/-T62 SHEET, 0.020 THICK, PER QQ-A-250/11 OR
AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.020)
OR
ALUMINUM 5052-H32 SHEET, 0.020 THICK, PER QQ-A-250/8 OR
AMS 4016 (REF DART SPEC M5052H32S.020)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) SEE SHEET 3 FOR DETAIL A
- 7) PARTS ARE SYMMETRIC ABOUT ϕ

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SHOP COPY

UNCONTROLLED COPY
ENGINEERING
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 86625 M-5
12/03/15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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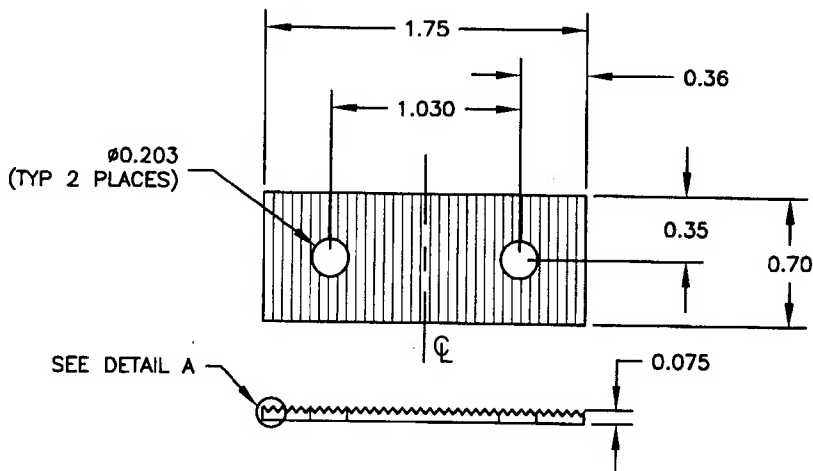
NOTE: Date & initial all entries



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 2 OF 3
DATE 07.02.19	TITLE PLATE		SCALE 1:1

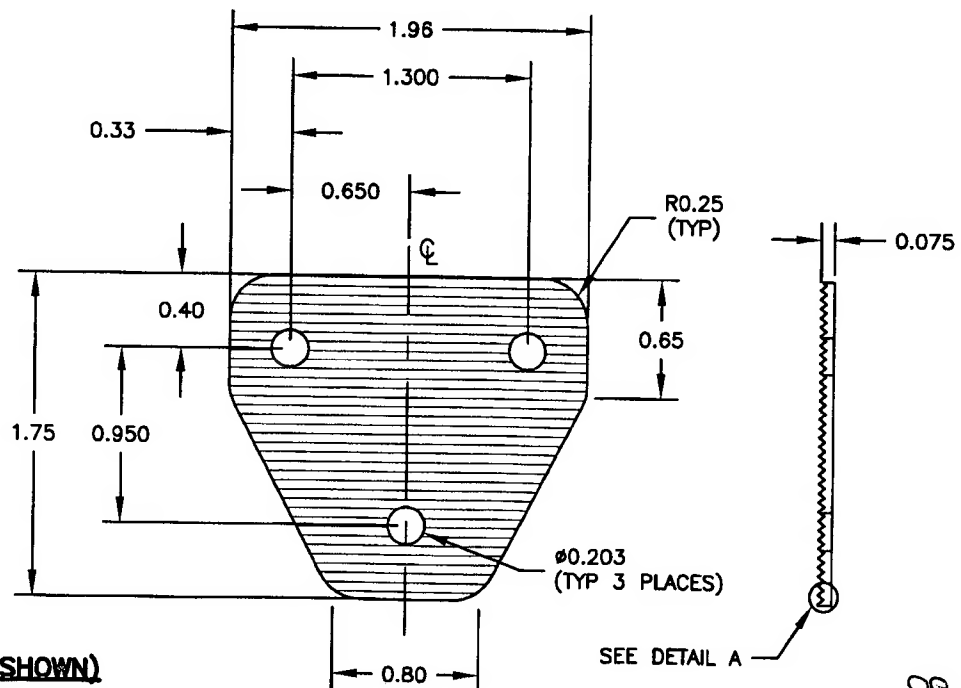
RELEASED

07.02.20



D3238-5 PLATE (SHOWN)

D3238-15 PLATE (SAME, EXCEPT 0.020 THICK AND NO SERRATIONS)



D3238-21 PLATE (SHOWN)

D3238-31 PLATE (SAME, EXCEPT 0.020 THICK AND NO SERRATIONS)

06925

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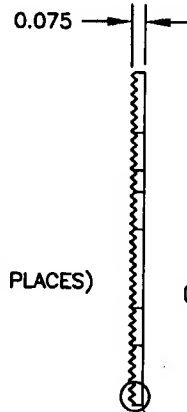
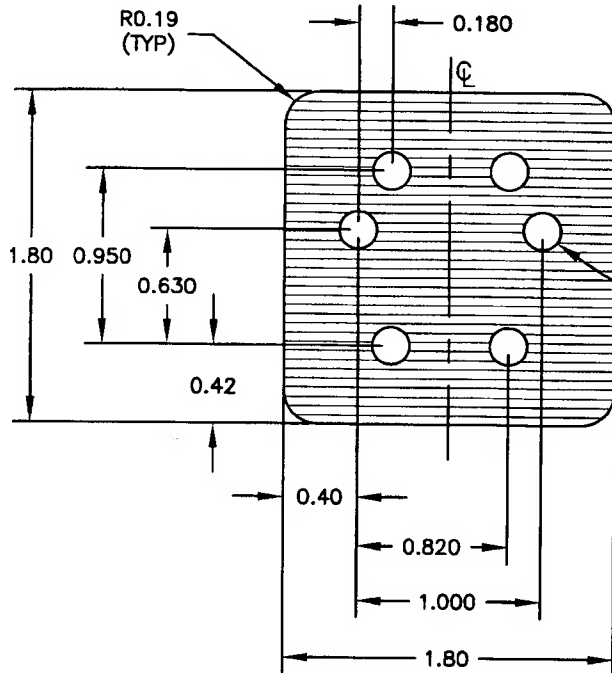
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CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 3 OF 3
DATE 07.02.19	TITLE PLATE		SCALE 1:1

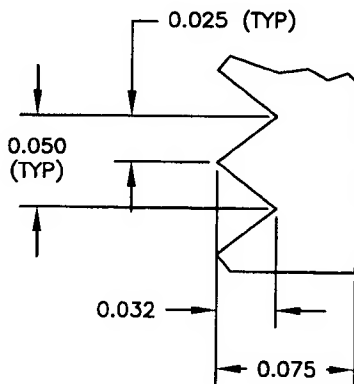


RELEASED

07.02.20

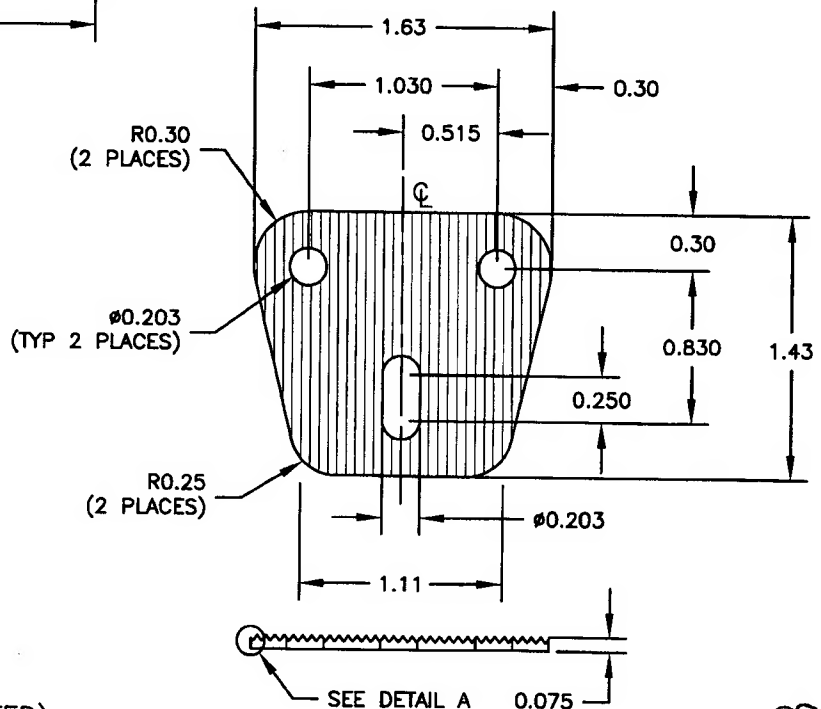
D3238-23 PLATE (SHOWN)
D3238-33 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

SEE DETAIL A



DETAIL A

RIDGE DETAIL (VIEW MAY BE ROTATED)
SCALE 10:1



D3238-25 PLATE (SHOWN)

D3238-35 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

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Dart Aerospace Ltd

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